

Work Order ID 152366

Monday, October 24, 2016 8:23:47 AM

646.3510
5.366
P C V N / C 3***152366***

Page 1

Item ID: 646.3510

Revision ID:

Item Name: Strut

Start Date: 10/24/2016 Start Qty: 10.00

Required Date: 10/28/2016 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

OCT 24 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3500	N/C 3								
110		0.00							
110									
Waterjet	Memo	0.10							
FLOW CNC Waterjet	1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Dwg Rev: <u>C3</u> Prog Rev: <u>C3</u> 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.02							
Quality Control									

10 R 16-10-25

10 R 16-10-25

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

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Item ID: 646.3510

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut

Start Date: 10/24/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/28/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.03

Quality Control

DAS

38

9-88

OCT 25 2016

140

0.02

140

Small Fab

Memo

0.23

Small Fab

1- Fabricate tube as per dwg USE DT10290 PUNCH

DAS

38

9-88

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.03

Quality Control

DAS

38

9-88

DAS

38

9-88

OCT 26 2016

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Item ID: 646.3510

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Revision ID:

Stop ***NS2***

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Weld per dwg A/R S.S. rod Batch: M134442

0.00

160

Large Fab

Memo

0.37

Large Fab

Weld tube to plate as per dwg. DT9867
Weld end were tube is punch.

(10)

Dx 1/2
16/10/26

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00

170

QC

Memo

0.00

Quality Control

(10)

16-10-31

DAS
9
9-89

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.03

Quality Control

(10)

16-10-31

DAS
9
9-89

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

0.00

220

SprayPaint

Spray Painting

Memo

Prime as per dwg (see note 3)

Batch: 134100

0.02

10

9-11-15

230

0.00

230

QC

Quality Control

QC14- Inspect Spray Paint

Memo

0.02

10

DAS
38
9-89

NOV 11 2016

240

0.00

240

Packaging

Packaging

Memo

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

0.00

CCK 108A

10

DAS
6
9-89

NOV 14 2016

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.17

Quality Control

16/11/15

DAS
21
9-89

NOV 14 2016

Picklist Print

Monday, October 24, 2016 8:23:53 AM

Page 1

Work Order ID: 152366

152366

Parent Item: 646.3510

646.3510

Parent Item Name: Strut

Start Date: 10/24/2016

Required Date: 10/28/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	72.5700		0.292632			

M304S16GA

304/316 Sheet .063

**

Q 16-10-25

Location	Loc Qty	Loc Code
MAT010	72.57	
<u>m135377</u>	7.12	
m135559	1.45	
m135689	64	

M304TR0.500W.049

Purchased

No

f

70.4388

8.768421

M304TR0.500W.049

304 RD Tube .500 x .049W

**

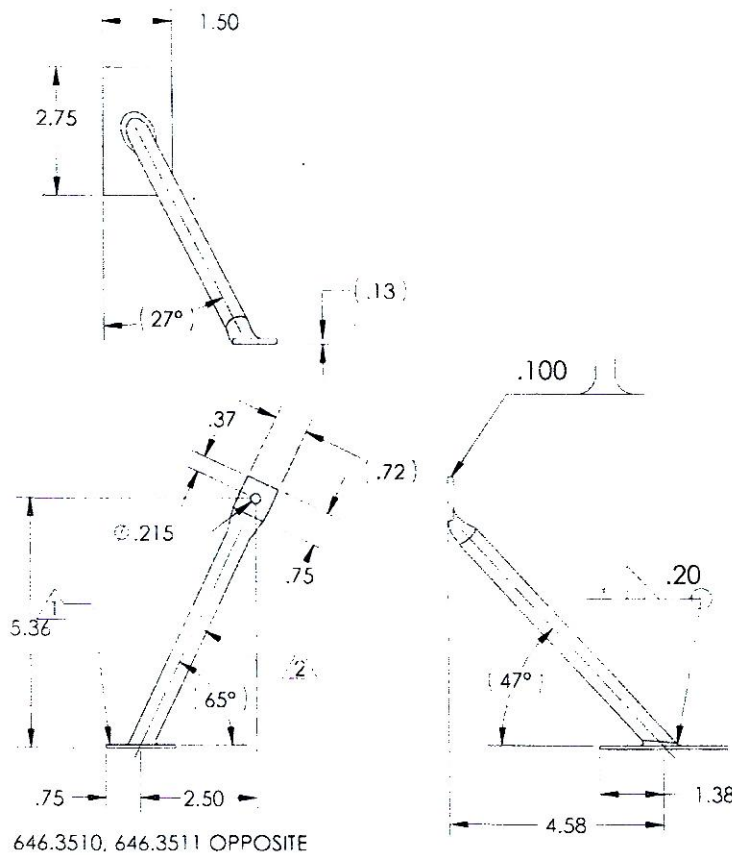
DTL 16/10/26

Location	Loc Qty	Loc Code
GA002	70.438836	
M127937	1.1741	
<u>M132872</u>	29.264736	
M135325	40	

14,16

NOTES:

- 1 MATERIAL: 6061-T6 ALUMINUM IAW AMS-QQ-A-250/11;
.062" THK.
- 2 MATERIAL: 6061-T6 ALUMINUM IAW AMS-WW-T-700/6
.500" OD; .062" WALL THK
- 3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2
COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
4. DEBURR AND BREAK ALL SHARP EDGES
5. WELDS IAW MIL-STD-2219.
TIG WELD WITH FILLER ROD



646.3510 SHOWN
646.3511 OPPOSITE

UNINCORPORATED ECN(s)

02197, 02440, 04274

QTY	REV	DATE	DESCRIPTION	MATL	SPEC
1	1	02/19/97	STRUT		
1	2	02/19/97	STRUT		
1	3	02/19/97	STRUT		
1	4	02/19/97	STRUT		
1	5	02/19/97	STRUT		
1	6	02/19/97	STRUT		
1	7	02/19/97	STRUT		
1	8	02/19/97	STRUT		
1	9	02/19/97	STRUT		
1	10	02/19/97	STRUT		
1	11	02/19/97	STRUT		
1	12	02/19/97	STRUT		
1	13	02/19/97	STRUT		
1	14	02/19/97	STRUT		
1	15	02/19/97	STRUT		
1	16	02/19/97	STRUT		
1	17	02/19/97	STRUT		
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1	21	02/19/97	STRUT		
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